

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021049**Date Inspected:** 11-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yang Bai Qiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Splice Plate**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG, Bay 1

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as 20TR2-013 & 009, located on Traveler Rail 20TR2-004, welder is identified as 059450, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G-(F)-ESAB-Repair.

FCAW welding of weld joint identified as E2-SB1-024-025, located on Steel Barrier E2-SB1-024, welder is identified as 068864, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with Welding Repair Report WPS-345-FCAW-2G-(F)-ESAB-Repair & Welding Repair Report B-CWR-2377.

FCAW welding of weld joint identified as 20TR2-03-011, located on Traveler Rail 20TR2-035, welder is identified as 216575, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G-(F)-ESAB-Repair & B-WR16965.

OBG Bay #28

WELDING

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as SA3114D-009-003-004, located on Splice Plate SA3114D-009, welder is identified as 062259, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as Splice Plate identified as SA3117B-001-003 & 004, located on Splice Plate as SA3117B-001, welder is identified as 062259, ZPMC Quality Control (QC) is identified as Mr. Yang Bai Qiang. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified as E5-SB15-001-088, located on Steel Barrier E5-SB15-001, welder is identified as 062259, ZPMC Quality Control (QC) is identified as Mr. Ai Wei. The welding variables recorded by QC appeared to comply with Welding Repair Report WPS-345-FCAW-2G-(F)-ESAB-Repair & Welding Repair Report B-CWR-2377.

OBG, Bay 16

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified as W5-SB2-012-057, located on Steel W5-SB2-012, welder is identified as 201071, ZPMC Quality Control (QC) is identified as Mr. Wang Zhen. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as W5-SB1-105-028, located on Steel barrier W5-SB1-105, welder is identified as 201888, ZPMC Quality Control (QC) is identified as Mr. Wang Zhen. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as W5-SB1-001-042, located on Steel barrier W5-SB1-001, welder is identified as 201879, ZPMC Quality Control (QC) is identified as Mr. Wang Zhen. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

FCAW welding of weld joint identified as W5-SB1-111-055, located on Steel barrier W5-SB1-111, welder is identified as 201888, ZPMC Quality Control (QC) is identified as Mr. Wang Zhen. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-ESAB.

SMAW welding of weld joint identified as W5-SB1-069-103, located on Steel barrier W5-SB1-069, welder is identified as 067656, ZPMC Quality Control (QC) is identified as Mr. Wang Zhen. The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert
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Quality Assurance Inspector

Reviewed By:	Hall, Steven
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QA Reviewer
